

SMALL FAB

6094



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RBT18520
Job Sheet 178060



005318

7-30

Part No: RBT18520

Job Qty: 1 ea

Part Name: Main Rotor Damper Load Test Device



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/25/18

Job Tracking No:

Due Date: 8/15/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT18520 REV:11 IPP REV A 18.02.07 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/15/18	8/15/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	1 pcs	8/15/18	8/15/18	0.08	0.33	Small Fab-9		MLL DAS
110	QC	1 pcs	8/15/18	8/15/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	8/15/18	8/15/18	0.00	0.00	Packaging3-2		9-88
140	QC21-FG	1 Ea	8/15/18	8/15/18	0.00	0.00	QC21		max 18.09.07

Part Op 100 - Assemble
Descriptions: 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
GA 10164	LG. Pistol Case, Plastic	1 Ea (1 ea)	100-Small Fab	5096400
60 20625A914	Dial Indicator Atchmnt Agd-2 Dial	1 Ea (1 ea)	100-Small Fab	5044126
44 5416K41	SS Hose Clamp 3.5" Dia.	1 Ea (1 ea)	100-Small Fab	5044125
61 90108A417	Flat Washer 3/8" Plated.	2 Ea (2 ea)	100-Small Fab	5044121
70 91259A583	Shoulder Screw 5/16" Shoulder Dia, 1" L Shoulder, 1/4"-20 Thread	1 Ea (1 ea)	100-Small Fab	5068316
55 92845A245	18-8 Ss Extended (Dog) Point Socket Set Screw 10-24 Thread, 1/2" Length	2 Ea (2 ea)	100-Small Fab	5044124
56 93839A815	Hex Nut 3/8-24 Unf	2 Ea (2 ea)	100-Small Fab	5044120
139 95615A120	1/4-20 Nylock Nut	1 Ea (1 ea)	100-Small Fab	5044123
158 AGD-2	1" Dial Indicator 0" to 1" Range	1 Ea (1 ea)	100-Small Fab	5044136
33 FPSC4-10R	TBD	1 Ea (1 ea)	100-Small Fab	5044352
33 FPSC5-10R	TBD	1 Ea (1 ea)	100-Small Fab	5044353
145 RBT18520-1	Lift Device Frame	1 Ea (1 ea)	100-Small Fab	5044963
145 RBT18520-11A	Weight Assembly	1 Ea (1 ea)	100-Small Fab	5106923
61 RBT18520-15	Clevis Bracket	1 Ea (1 ea)	100-Small Fab	5044449
145 RBT18520-16	Indicator Bracket	1 Ea (1 ea)	100-Small Fab	5051546
145 RBT18520-5	Weldment	1 Ea (1 ea)	100-Small Fab	510707
145 RBT18520-7	Pivot Bar Weldment	1 Ea (1 ea)	100-Small Fab	5053641
145 RBT18520-9A	Extension Assembly	2 Ea (2 ea)	100-Small Fab	5058173



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Container No: S108042



Part: RBT18520

Job No: 178060

Serial No/Batch: S108042

Revision: 11

Inspector:

Exp Date:

Instructions:

Date: 09/05/18

Job Allocations

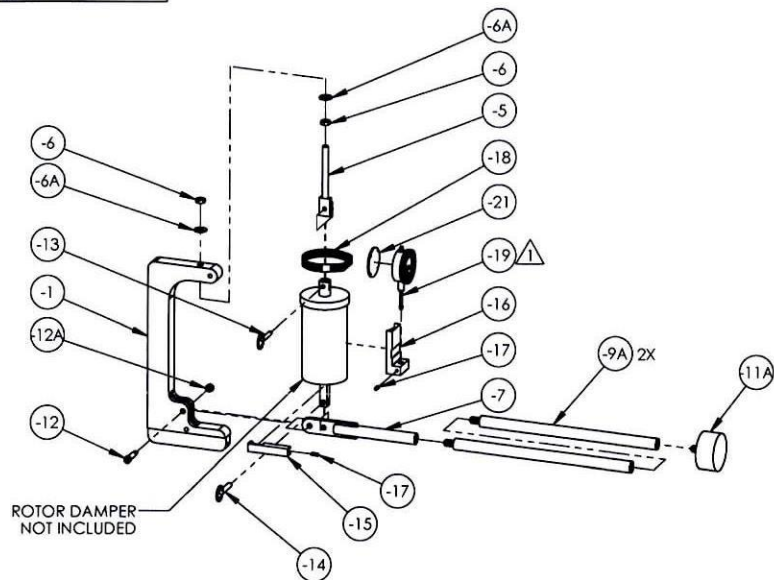
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab	10164	1	5	0
	20625A914	1	2	0
	5416K41	1	8	0
	90108A417	2	96	0
	91259A583	1	10	0
	92845A245	2	21	0
	93839A815	2	46	0
	95615A120	1	98	0
	AGD-2	1	3	0
	FPSC4-10R	1	8	0
	FPSC5-10R	1	8	0
	RBT18520-1	1	4	0
	RBT18520-11A	1	0	0
	RBT18520-15	1	4	0
	RBT18520-16	1	4	0
	RBT18520-5	1	0	0
	RBT18520-7	1	4	0
	RBT18520-9A	2	2	0

Part Specifications

Specifications could not be found.

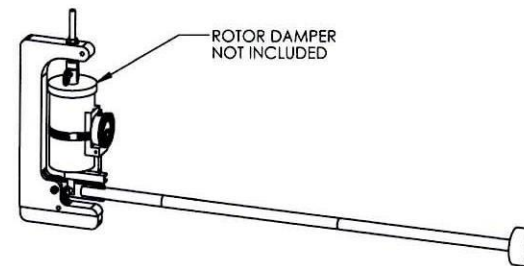
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ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
					-1	1	FRAME	6061		2
					-3		TOP BOLT TAB	1018/1020 CR		3
			X		-5	1	TOP BOLT WELDMENT			4
					-5A	1	ALL THREAD	STEEL	3/8-24 (MCMaster-CARR #92580A109) MODIFIED	5
				B/O	-6	2	JAM NUT	STEEL	3/8-24, GRADE 8 (MCMaster-CARR #93839AB15)	1
				B/O	-6A	2	FLAT WASHER	STEEL	Ø3/8 (MCMaster-CARR #90108A417)	1
			X		-7	1	PIVOT BAR WELDMENT			6
					-7A	1	PIVOT BAR TAB	1018/1020 CR		7
					-8	1	TUBE	CDS		8
					-9	1	EXTENSION	CDS		9
			X		-9A	2	EXTENSION ASSEMBLY			10
				B/O	-10	1	SOCKET HEAD SET SCREW	STEEL	7/16-24 X 1-1/2 (MCMaster-CARR #91375A673)	10 & 12
					-11	1	WEIGHT	BRASS		11
			X		-11A	1	WEIGHT ASSEMBLY			12
				B/O	-12	1	SOCKET HEAD SHOULDER BOLT	STEEL	1/4-20 X 7/16, Ø5/16 X 1 SHOULDER (MCMaster-CARR #91259A583)	1
				B/O	-12A	1	NYLON LOCK NUT	STEEL	1/4-20 (MCMaster-CARR #95615A120)	1
				B/O	-13	1	QUICK RELEASE PIN	S.S.	Ø1/4 X 1 (ESSENTIA COMPONENTS #FFSC4-10R)	1
				B/O	-14	1	QUICK RELEASE PIN	S.S.	Ø5/16 X 1 (ESSENTIA COMPONENTS #FFSC5-10R)	1
					-15	1	CLEVIS BRACKET	6061		13
					-16	1	INDICATOR BRACKET	6061		14
				B/O	-17	2	SOCKET HEAD SET SCREW (DOG POINT)	S.S.	#10-24 X 1/2 (MCMaster-CARR #92845A245)	1
				B/O	-18	1	HOSE CLAMP	S.S.	Ø3-1/16 TO Ø4 X 1/2 (MCMaster-CARR #5416K41)	1
				B/O	-19	1	1 in. DIAL INDICATOR	(PAC-WEST #AGD-2) Δ		15
				B/O	-21	1	FLAT BACK FOR DIAL INDICATOR	FOR AGD GROUP 2 DIAL INDICATOR (MCMaster-CARR #20625A914)		1
				B/O	-23	1	LARGE PISTOL CASE	PLASTIC	(R3R GROUP #10164)	N/S
ASSY -1A	ASSY -9A	ASSY -7	ASSY -5	B/O	DAMP ER					

REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
1		-10 WAS CUT STUDS; -16 TOLERANCE REDUCED TO ENSURE CLEARANCE FOR DIAL INDICATOR;	8/17/2000	-	-	
2		CUT -1 FRAME BACK TO .375 NEXT TO Ø5/16 HOLE FOR CLEARANCE.	10/30/2001	-	-	
3		CHANGED -1 SCREW HOLE FROM "REAM TO .3125"; -11 ADDED MACHINE TO WEIGHT & SEE TESTING & ENGRAVING; ALSO CREATED A TESTING & WEIGHT CERTIFICATION DWG.	8/16/2007	WP	RW	
4		COMBINED NINE FILES INTO ONE; INSTALLED NEW TITLE BLOCK, BOM, & REV. TABLE; CREATED CUSTOMER NEW DWG'S; SEPARATED -5 THREADED ROD & -5 TOP BOLT TO -5 TOP BOLT WELDMENT & -5g ALL THREAD; SEPARATED -7 TAB & -7 PIVOT BAR TO -7 PIVOT BAR WELDMENT & -7g PIVOT BAR TAB; CHANGED -12 Ø5/16x1 PIN TO -12 SCREW & -12g NYLOCK NUT; CHANGED STAKE OR PIN -10 TO USE LOCITITE 609.	11/29/2007	WP	RW	
5		ADDED SUPPORT SUPPORT WEIGHT NOTE TO CUSTOMER INSTRUCTIONS, AND -9 MUST REMAIN LEVEL TO TESTING INSTRUCTIONS, PER DAVE'S NOTES.	11/29/2007	WP	DW	
6		CHANGED -1 PIVOT HOLE FROM Ø.257 TO Ø5/16 REAMED; -7g PIVOT HOLE FROM Ø.257 TO Ø5/16 REAMED; AND -12 FROM SOCKET HEAD CAP SCREW 1/4-20 X 1-1/2 TO SOCKET HEAD SHOULDER BOLT Ø5/16 X 1; APPLIED PHANTOM BOXES TO PARTS FOR CLARITY. UPDATED CUSTOMER DWGS.	6/11/2009	WP	G.E.	
6A		CORRECTED DIM P/N -5g FROM 1/2-24 UNF.	7/30/2009	RJC		
7		CHD P/N -10 SETSCREW DEPTH TO .75 PER G.E.	9/28/2009	RJC		
8		CHANGED INSIDE HOLE ON -7A FROM Ø.313 TO REAM Ø.3125. ALSO CORRECTED ERROR IN BOM, -14 WAS REED #FFSC-4-10, NOW #FFSC-5-10R.	9/28/2009	WP		
8A		CHD Ø.375 REAMED TO THRU PER G.E.	8/24/2010	WP	G.E.	
8B		ADDED CUSTOMER INFO TO MANUFACTURING DWGS. PER R.W.	11/22/2010	RJC	RW	
8C		ADDED -19 TO SHOW MODIFICATION OF DIAL INDICATOR AND MOUNTING PER R.W.	7/12/2011	RJC	RW	
8D		CHD TITLEBLOCK TOLERANCES FROM .XXX ±.005 & .XX ±.01 PER G.E.	2/15/2012	RJC	RW	
9		MOVED ALL PARTS TO SEPARATE SHEETS, -1 ADDED Ø.25 TOOLING HOLE, -14 ADDED R.25 LEFT .30 DIM TO THEORETICAL POINT.	8/7/2013	RJC	DW	
10	16-0096	UPDATED TO NEW STANDARDS. ADDED CALIBRATION NOTE, -1 CHD DIMS WAS Ø.375 THRU IS Ø.375 ±.003, WAS REAM Ø.3125 ±.0152-3192 THRU ALL (S.F. -12), WAS 1.00 ±.2X 1.00, WAS (125) ±.13. -3 CHD MATL WAS 1018 ±.1018/1020 CR, CHD DIM WAS Ø.250 ±.005, -13 IS Ø.250, -254 THRU ALL (S.F. -13), -8A CHD DIMS WAS 3/8-24 UNF IS (3/8-24 UNF-2A), WAS 3.625 ±.3.63, ADDED B/O #92580A109, -4A ADDED B/O #93839AB15, -4A ADDED B/O #90108A417, -7 DELETED SAND TO FIT CALLOUT, -7A CHD MATL WAS 1018 ±.1018/1020 CR, CHD DIMS WAS Ø.313 ±.005, -14 IS Ø.3125-3165 THRU ALL (S.F. -14), WAS REAM Ø.313 ±.0152-3192 THRU ALL (S.F. -12), WAS .310 ±.310 ±.000, -Ø10 (S.F. -8), WAS .500 ±.2X .500, -8 ADDED RADIUS TO END OF SLOT, CHD DIMS WAS .188 WALL ±.19, WAS .315 SLOT ±.005, -7A IS .315 ±.010, -Ø.000 (S.F. -7A), -9 CHD DIM WAS .188 WALL ±.19, -9A ADDED TO BOM, -18 ADDED B/O #91375A673, -11 REMOVED RB LOGO, ACTUAL WEIGHT, AND OPERATORS INITIALS FROM ENGRAVE NOTE, -11A ADDED TO BOM, -12A ADDED B/O #95615A120, -18 CHD DIM WAS R.125 ±.125 FULL R, -18 CHD DIMS WAS R.125 ±.125 FULL R, WAS 10-24 UNC IS 10-24 UNC-28 ±.1.86, -17 ADDED B/O #92845A245, -18 ADDED B/O #5416K41.	8/4/2016	DPD	JAG	
11	17-0069	-9A CHD LOCITE NUMBER WAS 609 ±.262, -11 CORRECTED SPELLING ON ENGRAVING WAS "CALIBRATED" TO "CALIBRATED", -11A CHD LOCITE NUMBER WAS 609 ±.262, -19 WAS MODIFIED IS B/O, DELETED DWG, -21 ADDED TO BOM QTY 1, -23 ADDED TO BOM QTY 1.	3/22/2017	DPD	JAG	



NOTE:
Δ CALIBRATED UPON CUSTOMER REQUEST.

DART AEROSPACE	
TITLE ROTOR DAMPER TEST DEVICE	
DWG NO. RBT18520	
REV 11	
MATL	UNLESS OTHERWISE SPECIFIED
FEAT	DIMENSIONS ARE IN INCHES
FRSH	XXX ±.010 FRACTIONS ± 10
SPEC	XX ±.03 ANGLES ±1°
	X ±.1 SURFACES ±125
DRAWN BY:	COLE
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QIA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	1:8
DATE	8/17/2000
SHEET 1 OF 17	